

Work Order ID 163827

163827

Page 1

Monday, July 10, 2017 11:56:25 AM

Item ID: 646.3719

Revision ID:

Item Name: Doubler

Start Date: 7/10/2017

Required Date: 7/28/2017

Reference:

646.3719

B 163827

REV. A

Start Qty: 6.00

Req'd Qty: 6.00

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

DAS

Approvals:

Process Plan:

Date: Jul 12 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3700

A

110

0.02

110

Waterjet

FLOW CNC Waterjet

Memo

0.16

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Q

SC 17/07/14

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.06

Q

SC 17/07/14

DAS

33

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 163827

Monday, July 10, 2017 11:56:25 AM

163827

Page 2

Item ID: 646.3719 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/10/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo Issue P/O to ATG : <u>27223</u> 1- Black Anodize as per Dwg 646.3700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	0.00 0.12				<u>6</u>			DAS 38 9-89 JUL 17 2017
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>27223</u> 1- Black Anodize as per Dwg 646.3700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	0.00 1,080.00				<u>6</u>	<u>h</u>		LAB 2017/07/27
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.12				<u>6</u>			DAS 6 1-89 AUG 1 8 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 163827

Monday, July 10, 2017 11:56:25 AM

163827

Page 3

Item ID: 646.3719 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/10/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo <i>1.0 mils thickness primer</i>	0.00 0.12				<i>6</i>			<i>DAS</i> <i>38</i> <i>9-89</i> AUG 22 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <i>CC105</i> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.06				<i>6</i>			AUG 23 2017 <i>DAS</i> <i>6</i> <i>9-89</i>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60							<i>17/9/5</i> <i>W 17/8/23</i> <i>DAS</i> <i>21</i> <i>9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
3ACI 3C 150									
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Monday, July 10, 2017 11:56:23 AM

Page 1

Work Order ID: 163827

163827

Parent Item: 646.3719

646 3719

Parent Item Name: Doubler

Start Date: 7/10/2017

Required Date: 7/28/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	212.6960	0.02778	0.175453			
M6061T6S 063									**				
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

212.696

M134604

49.01

M134830

2.456

M136251

22.4

M136790

9.9

M137041

2.52

M137175

27.3

M137513

75.51

M137599

23.6

SC 17/07/14

0.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

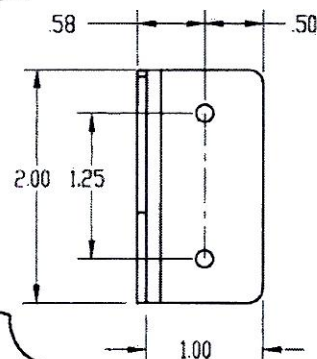
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

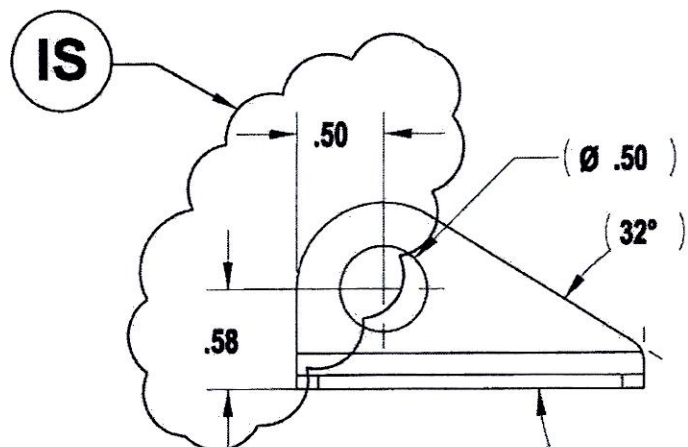
IS



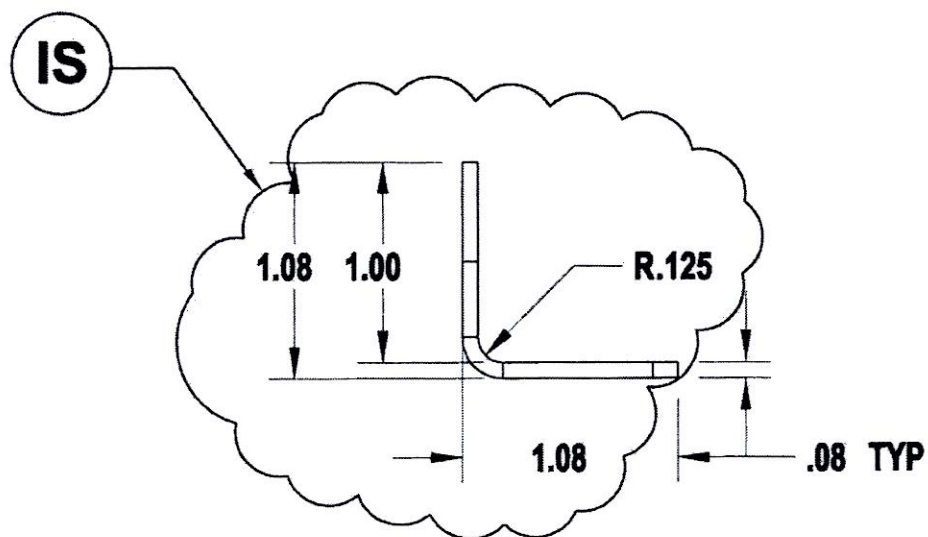
SHEET 7, ZONE B1 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163827 MLS
170712

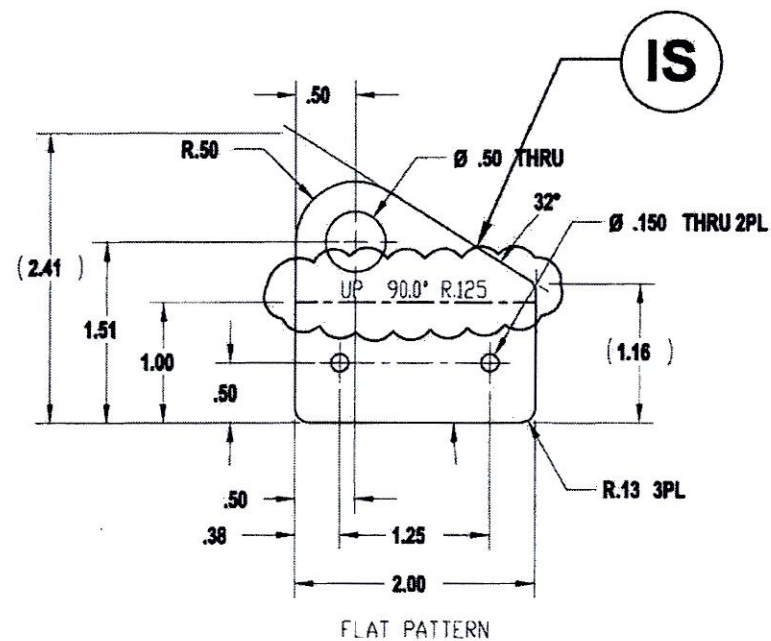
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

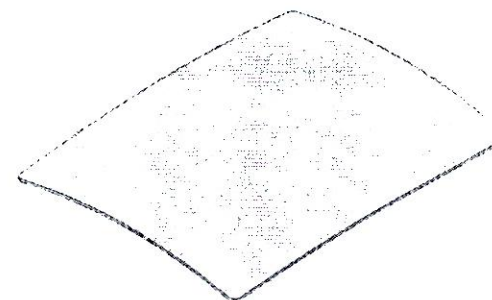
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN(0718)	01/02/97	PP/21

NOTES:

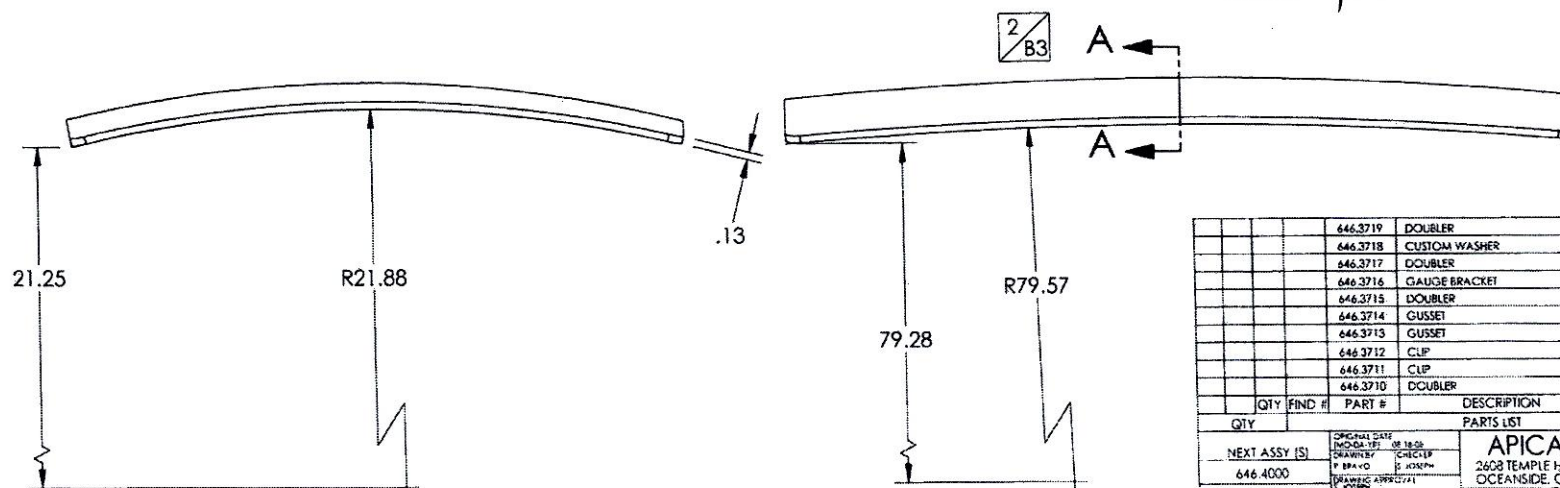
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

UNINCORPORATED ECN(s)

03702



QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		646.3719	DOUBLER	△	△
		646.3718	CUSTOM WASHER	△	△
		646.3717	DOUBLER	△	△
		646.3716	GAUGE BRACKET	△	△
		646.3715	DOUBLER	△	△
		646.3714	GUSSET	△	△
		646.3713	GUSSET	△	△
		646.3712	CLIP	△	△
		646.3711	CLIP	△	△
		646.3710	DOUBLER	△	△

PARTS LIST		SHEETMETAL	
QTY	DESCRIPTION	SCALE	SHEET
646.4000	646.4000	07M26	646.3700

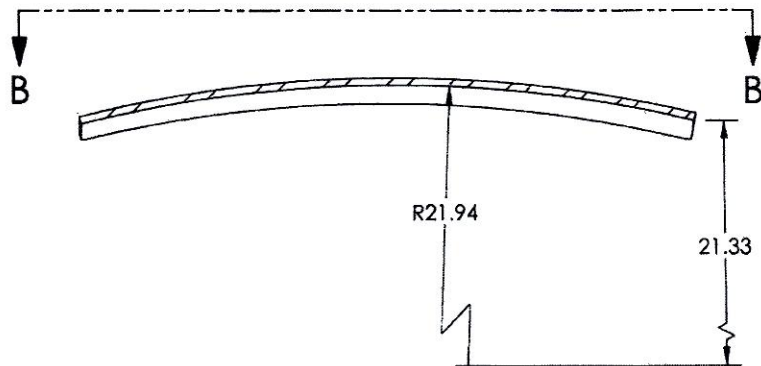
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

ORIGINAL DATE: 08/18/96
DRAWN BY: J. J. J. J.
CHECKED BY: J. J. J. J.
DATE: 08/18/96
CONTRACT NO: 646.3700

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

SEE CASE FORMS 07M26
SCALE: NONE
SHEET 1 OF 9

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SECTION A-A



R395.138

R.13 4PL

13.51

10.49

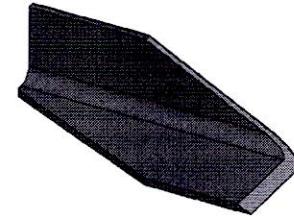
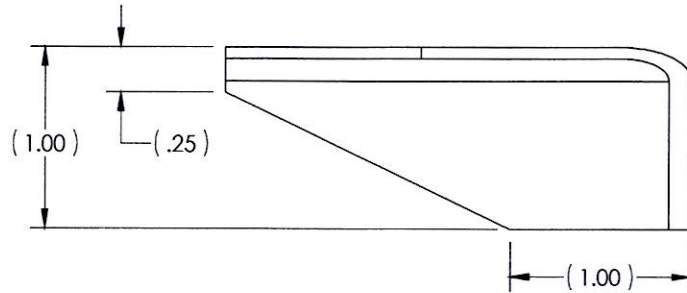
10.54

SECTION B-B

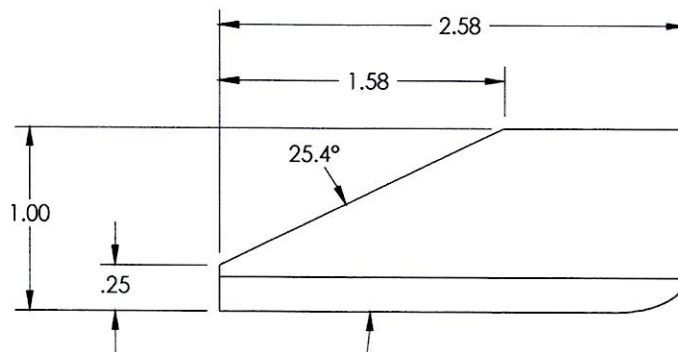
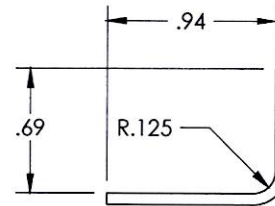
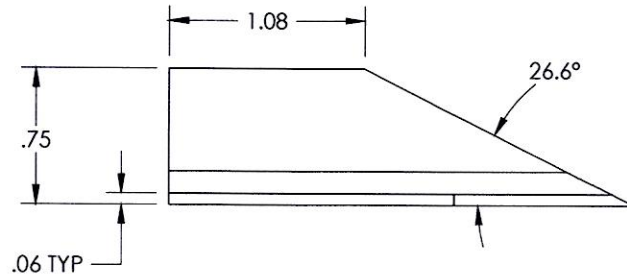
ORIGINAL DATE 08-18-09		APICAL INDUSTRIES	
DRAWN BY P. BRAYO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY S. JOSEPH		SHEETMETAL	
CONTRACT NO.		646.3700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		SCALE NONE	SHEET 2 OF 9
TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°			

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



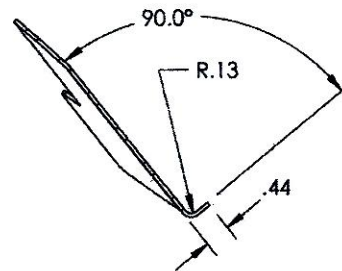
646.3711 SHOWN
646.3712 OPPOSITE



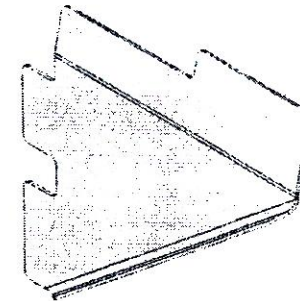
NEXT ASSY (S)	ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY P. BRAVO		
	CHECKED S. JOSEPH	SHEETMETAL	
	DRAWING APPROVAL S. JOSEPH		
	DATE 08-18-08	SCALE : NONE	SHEET 3 OF 9
	CONTRACT NO.		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SIZE B	REV. A
		CAGE CODE 07M26	DWG. NO. 646.3700

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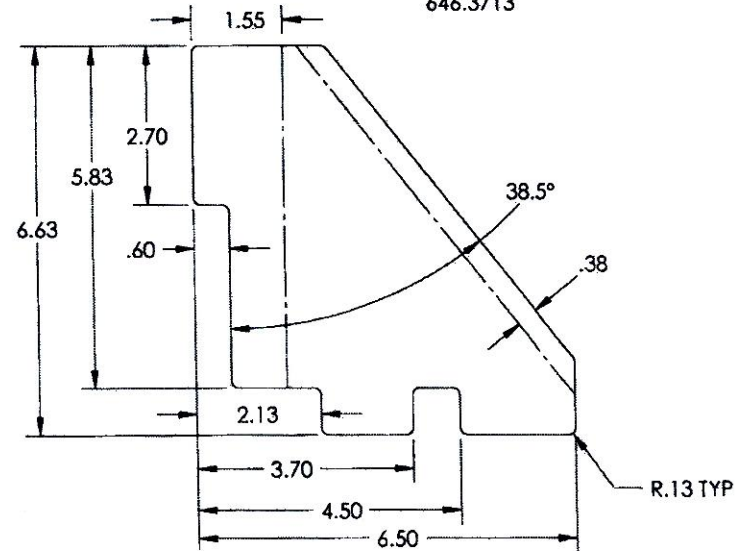
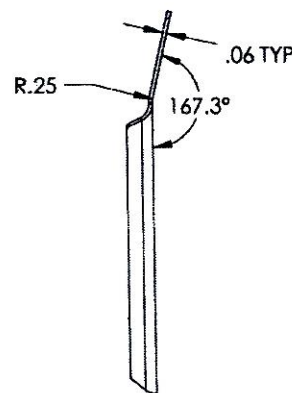
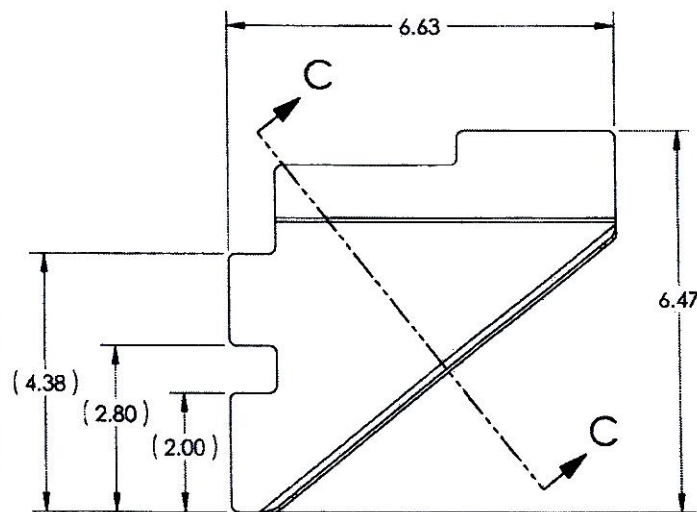
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

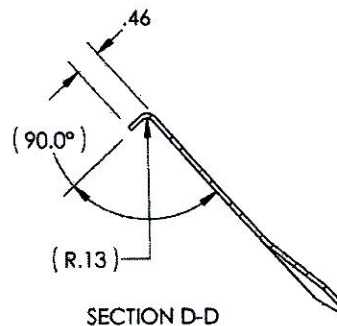
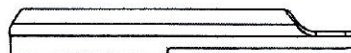


FLAT PATTERN

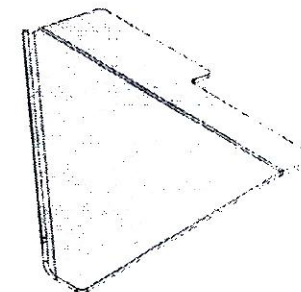
NEXT ASSY. (S)	ORIGINAL DATE	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE CA. 92056-3512 (760) 724-5300	
	DRAWN BY	CHUCKER		
	BY	15 JOURNAL		
	DATE	08-18-08		
MAILED OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	SHEET METAL		SEE CAGE CODE B 07M26 646.3700 SCALE: 1/4"=1"	
	SHEET 4 OF 9			
	REV. A			
	REV. A			

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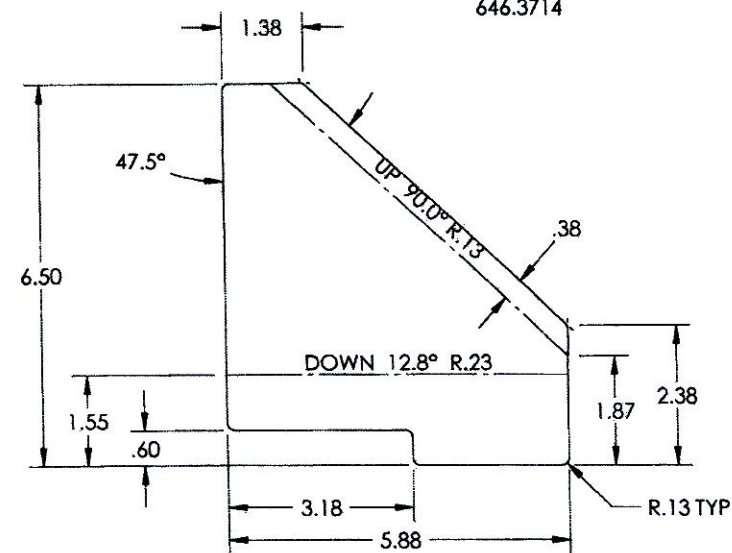
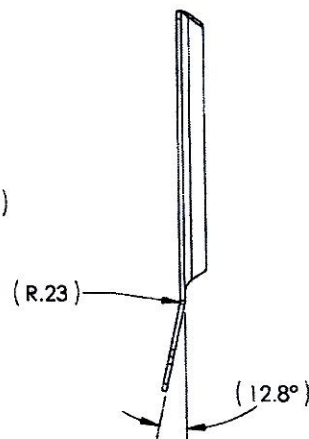
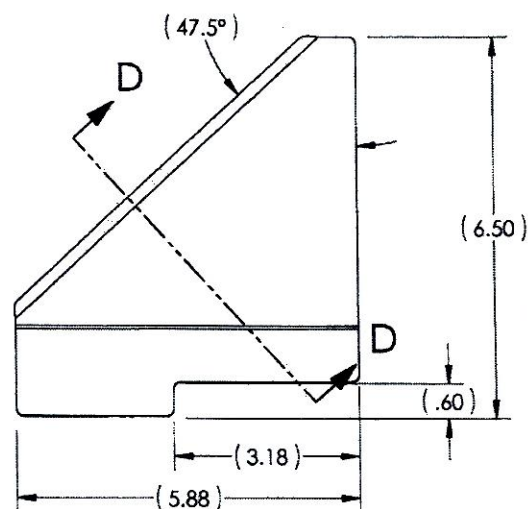
REV	DESCRIPTION	DATE	APPROVED



SECTION D-D



646.3714

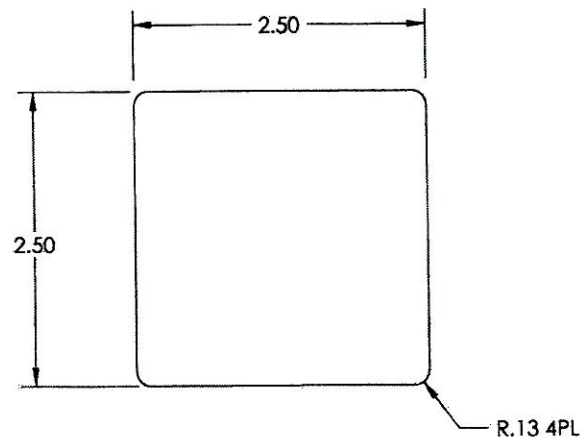


FLAT PATTERN

ORIGINAL DATE DESIGNED BY DRAWN BY P. BRAY CHECKED BY J. JOSEPH ENGINEERING APPROVAL J. JOSEPH CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 1760/724-5300 SHEETMETAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 ANGLES ± 1°	SHEET CODE B 07M16 DATE 07/16 SCALE NONE	PART NO. 646.3700 SHEET 3 OF 9
---	--	---	---

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



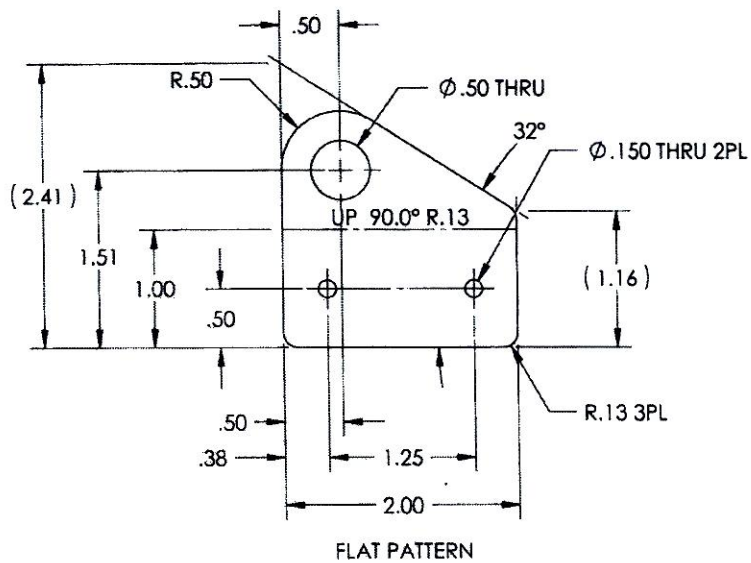
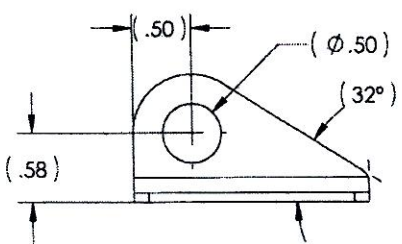
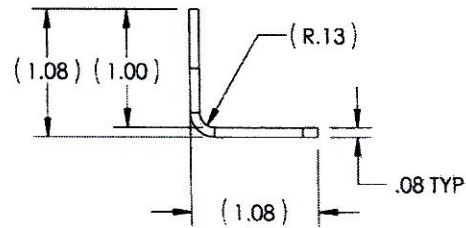
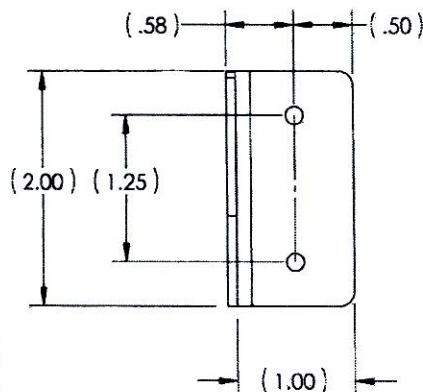
646.3715

NEXT ASSY (S)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. BRAYO		CHECKED S. JOSEPH		
DRAWING APPROVAL S. JOSEPH		DATE 08-18-08	SHEETMETAL	
CONTRACT NO.		UNITS: DIMENSIONS SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		
SET		CAGE CODE B 07M26	DWG. NO. 646.3700	REV A
SCALE: 1:100%		SHEET 6 OF 9		

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

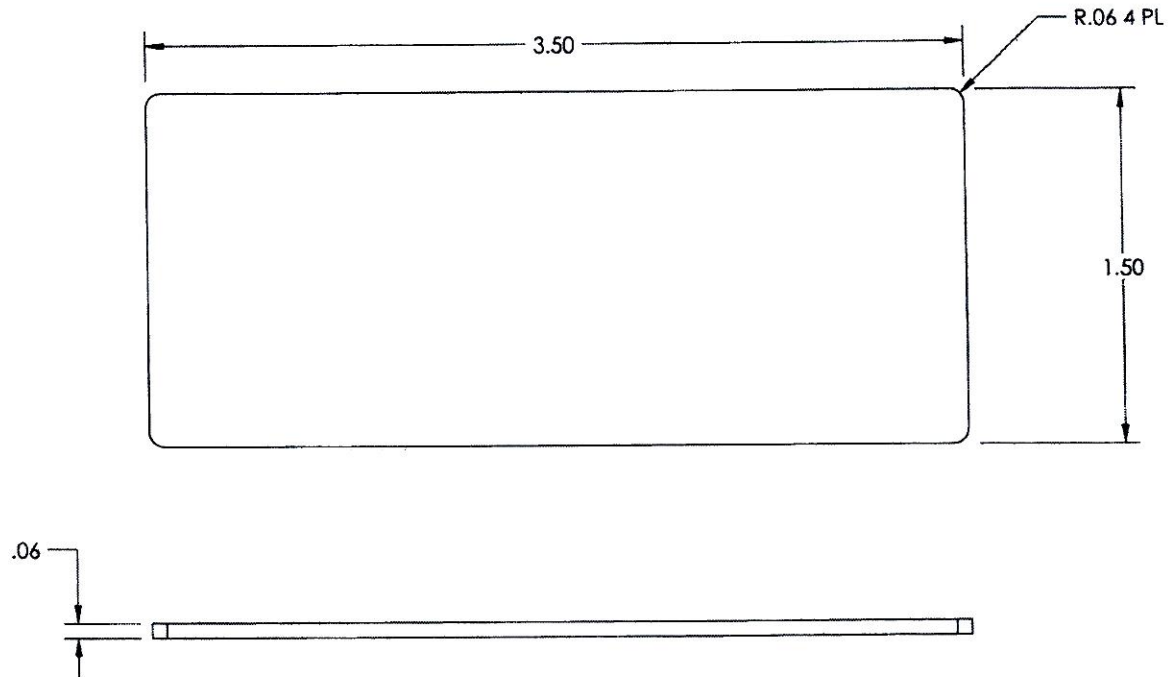
646.3716



NEXT ASSY (S)	ORIGINAL DATE	06-15-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	DESIGNED BY	C. JOHNSON		
	DRAWING APPROVED	1. JOHNSON	SHEETMETAL	
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED		SHEET CODE	DWG. NO.
	TOLERANCES ARE			
	2 PLACE DECIMALS ± .01		B 07M16	646.3700
	3 PLACE DECIMALS ± .005			
	ANGLES ± .5°		SCALE: 1"=1.00"	SHEET 7 OF 9

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

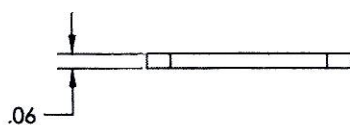
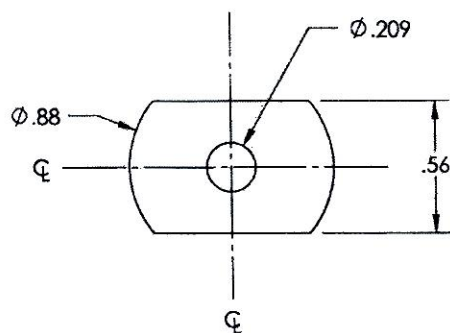


646.3717

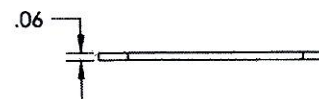
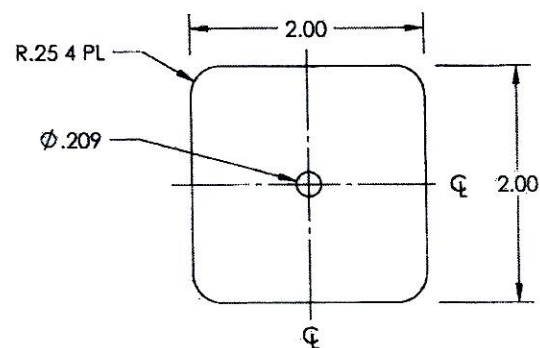
NEXT ASSY (S)		ORIGINAL DATE 08-18-08		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY P. BRAYO		CHECKED T. JOSEPH					
DESIGNED APPROVAL T. JOSEPH		DATE 08-18-08					
CONTRACT NO.							
UNLESS OTHERWISE SPECIFIED		TOLERANCES ARE:		SHEETMETAL 646.3700			
		2 PLACE DECIMAL ±.01					
		3 PLACE DECIMAL ±.005		SCALE: NONE			
		ANGLES ±.5°		SHEET 8 OF 9			

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY. IS)	ORIGINAL DATE	08-18-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	C. JENSEN		
	DESIGNED BY	P. BRAYO	SHEETMETAL	
	DESIGNED APPROVAL	1. JENSEN		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 1. PLACE DECIMALS 2.51 3. PLACE DECIMALS 2.51 4. ANGLES 1.5°	DATE	07/12/06	DWG. NO.	646.3700
	SCALE	1:1	SHEET	1 OF 1
	SCALE	1:1	SHEET	1 OF 1
	SCALE	1:1	SHEET	1 OF 1



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913717

Date: 18-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 649.4817 Shim Job: 21461	Rev: B PO: PO37223	Line: 18
4 ea	Part: D5156-7 Face Plate Black Anodize per MIL-A-8625F, Type II, Class 2, .000007-.0010" (.07 - 1 mils) Job: 21462	Rev: B PO: PO37223	Line: 19
11 ea	Part: 647.4113 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 21448	Rev: N/C PO: PO37223	Line: 5
6 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21451	Rev: A PO: PO37223	Line: 8
10 ea	Part: 646.3010 LH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21452	Rev: NC PO: PO37223	Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.		AUG 18 2017	
Made in Canada.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37223**

Purchase Order Date 7/26/2017

PO Print Date 7/28/2017

Page Number 3 of 8

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$0.0

7	163810	646.3012 Lower Guide	7/26/2017	5.00	50.00	\$0.0
			Yes			
			7/26/2017			

Hard Anodize and Prime as per Dwg 646.3000 REV. N/C

Line Total: \$0.0

x	163827	646.3719 Doubler	7/26/2017	6.00	50.00	\$0.0
			Yes			
			7/26/2017			

Anodize and Prime as per Dwg 646.3700 REV. A

Line Total: \$0.0

9	164113	646.3010 LH Half	7/26/2017	10.00	50.00	\$0.0
			Yes			
			7/26/2017			

Hard Anodize and Prime as per Dwg 646.3000 REV. N/C

Line Total: \$0.0

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

7/28/2017

DA6
38
9-86